

Work Order ID 164323

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Item ID: D3077-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg
 Start Date: 7/17/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						10			JUL 18 2017
QC	Memo	0.00							
Quality Control									
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Deburr to take measurement								
									DAS 38 9-89
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	1.03							
Hand Finishing									

(X10)  2017/07/21
BEB

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Item ID: D3077-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 7/17/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 JUL 21 2017
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : WA003								DAS 6 9-89 JUL 24 2017

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 7/17/2017 Start Qty: 10.00

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Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

17/7/25 *df*DAS
21
8-89

JUL 24 2017

Picklist Print

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Parent Item: D3077-1

D3077-1

Parent Item Name: Step Leg

Start Date: 7/17/2017

Required Date: 7/20/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: B02.11.18 Incorporated D3170-1 IPPKJ
IPP Rev: C 06-04-27 Manufactured on Water Jet JLM
IPP Rev: D 06-06-23 Now 6061-T6 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	19.3500	0.5833	6.14			

M6061T6S 080

6061-T6 .080 Sheet

**

07/17/17

Location

Loc Qty

Loc Code

MAT020

19.35

m136342

18.05

m136632

0.3

m137513

1

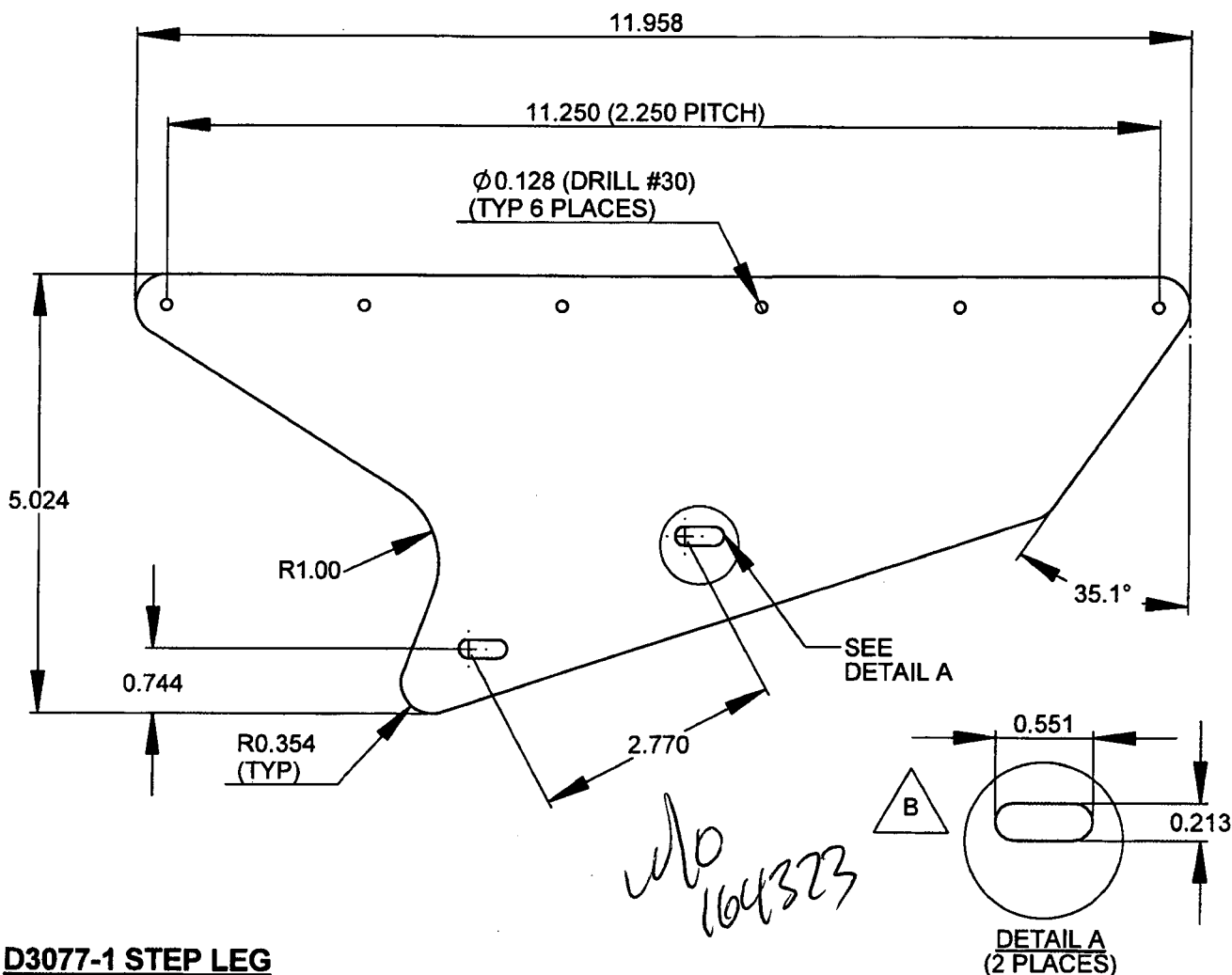
6



RELEASED

06.05.30

DESIGN	<i>CP</i>	DRAWN BY	<i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D3077
DATE	06.05.30	TITLE	STEP LEG	REV. B
A	02.09.11	NEW ISSUE		SHEET 1 OF 1
B	06.05.30	ADD 6061-T6 MATERIAL, ADD SLOTS		SCALE 1:2



D3077-1 STEP LEG

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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